

# Work Order ID 105256

Tuesday, July 30, 2013 4:26:54 PM

**\*105256\***

Page 1

Item ID: D2654-3

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web

Start Date: 7/30/2013 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 8/30/2013 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date: 13-07-31 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2654

F

100

0.00

**\*100\***

Skid tubes

Skid tubes

Skid tubes

Memo

0.00

- 1-Cut D2600-5 to length as per Dwg D2654
- 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654
- 3-Using the uni-bit, open holes to finish size as per Dwg D2654
- 4-Deburr holes and ends

110

0.00

**\*110\***

QC

QC5- Inspect part completeness to step on W/O

Quality Control

Memo

0.00

120

0.00

**\*120\***

Chemical Conversion Coat per QSI005 4.1

Hand Finish

Memo

0.00

Hand Finishing

J.D 13/8/1 ④

DP 13-8-1

J.D 13/8/1



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\*105256\*

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Tuesday, July 30, 2013 4:26:54 PM

Item ID: D2654-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Web

Start Date: 7/30/2013 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 8/30/2013 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00				4			B 13/08/01
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: LG  Memo	0.00  0.00				(4) J.D		13/8/01	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				MCS		13-08-09	MF 13-801



# Picklist Print

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Page 1

Work Order ID: 105256

\*105256\*

Parent Item: D2654-3

\*D2654-3\*

Parent Item Name: Web

Start Date: 7/30/2013

Required Date: 8/30/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured

No

100

Each

59.0000

1

4

\*D2600-5-108\*

\*\*

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

LG

59

73909

2

90684

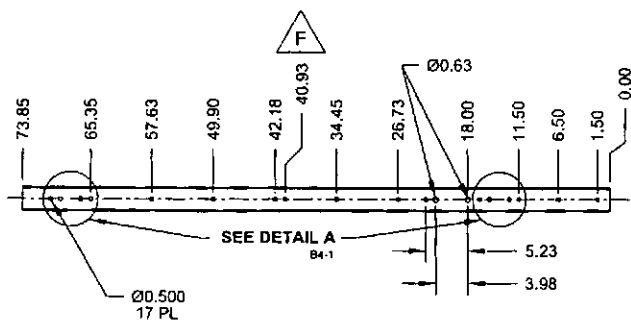
57

4

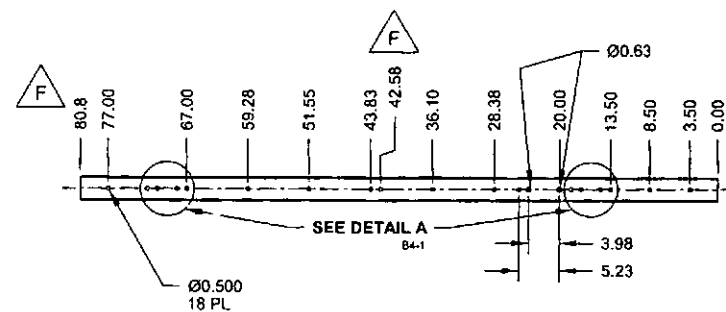
20

13/7/21

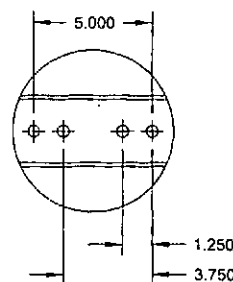




D2654-1 WEB



D2654-3 WEB



DETAIL A

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

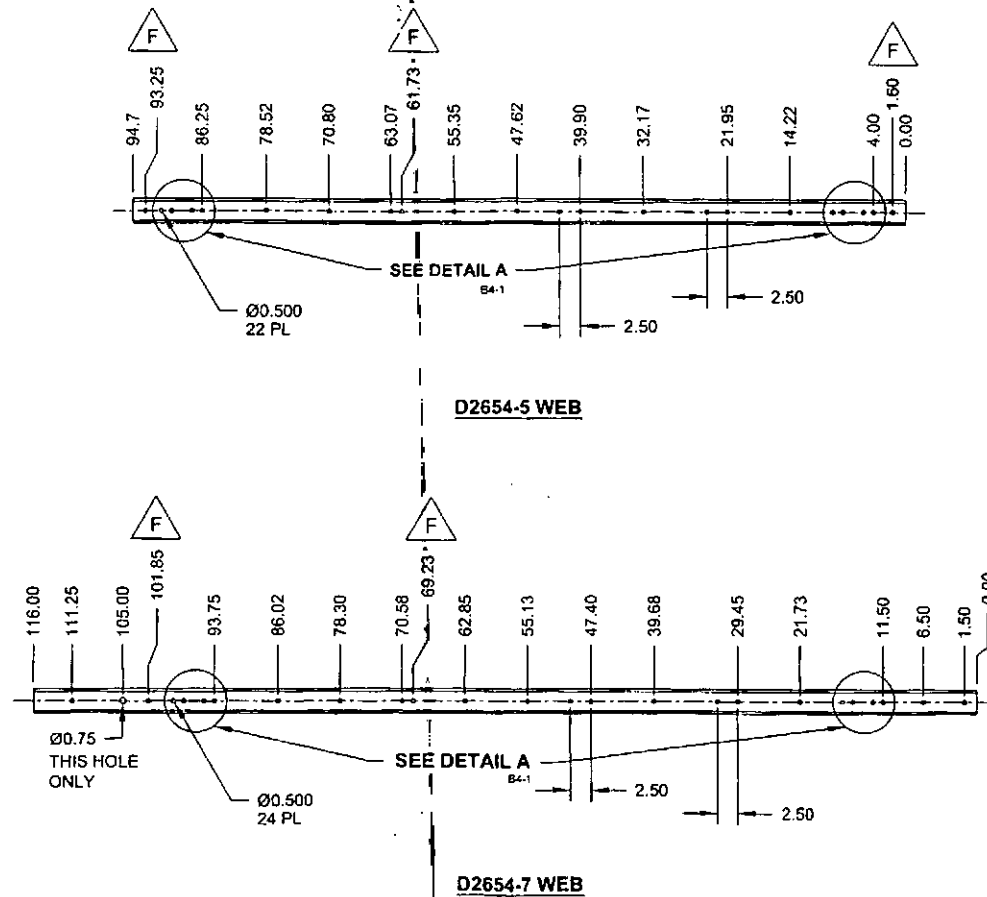
10S256  
P/B-07-30

RELEASED  
2011-09-12

F	ADDED ADDITIONAL HOLES ON 5/7, 80.8 WAS 80.3, INCORPORATED DEO D2654-E-2		SC	11.05.05
E	CHANGE LENGTHS, REFORMAT		CP	04.05.26
D	GHV HOLES CHANGED TO Ø0.53		CP	88.01.15
C	CHANGED HOLE PATTERN		CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438		CP	97.06.26
A	NEW ISSUE		CP	97.03.25
REV.		DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC		
DRAWN	SC	PORT HADLOCK, WA		
CHECKED	CP	DRAWING NO.	REV. F	
MFG. APPR.	CP	D2654	SHEET 1 OF 2	
APPROVED	CP	TITLE	SCALE	
DE APPR.	CP	WEB	NTS	
DATE	11.05.05			
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105256

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2011-09-12

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2654	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
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